

Date: Monday, 2/4/2008 11:23:23 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET ASSEMBLY		
Job Number	37155		Part Number	D3162041		
Estimate Number	10688		Drawing Number	D3162 REV C		
P.O. Number			Project Number	N/A		
This Issue	2/4/2008	S.O. No. :	Drawing Revision	C		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : MACHINED PARTS	Due Date	2/11/2008	Qty:	10 Um: Each
Previous Run	36733					
Written By	<i>KD 08/02/04</i>					
Checked & Approved By						
Comment	Est A 02.05.14 New Issue NG					
	Est Rev:B 08-01-15 now on water jet DD					

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet <i>17</i>
		Comment: Qty.: 0.0076 sf(s)/Unit Total : 0.0756 sf(s) 6061-T6 .063 Sheet Matl: 6061-T6 .063" thick (M6061T6S.063) <i>10S22S B 8-2-5</i>
2.0	WATER JET	FLOW WATER JET <i>B 8-2-S</i>
		Comment: FLOW WATER JET 1-Cut as per Dwg D3162 Dwg Rev: <i>C</i> <i>B 8-2-S</i> Prog Rev: <i>C</i> <i>(23)</i>
		Comment: 2-Deburr if necessary <i>B 8-2-S</i> <i>(23)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>B 8-2-S</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>S 08/02/05 (23)</i>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>S 08/02/08 (23)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges .005 to 0.010 Form as per drawing C'sink holes as per Dwg D3162 <i>D 08/02/08 (23)</i> <i>S 08/02/08 (23)</i> <i>E 08/02/11 (23)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Job Number: 37155		Part Number: D3162041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 <i>(23)</i>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>BR 08-02-12</i>
7.0	MS21059L3 	Nut Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Nut Plate Pick: Qty Part Number Description Batch		<i>1/03965 08/02/12</i>
8.0	MS20426AD34 	RIVET
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) RIVET Pick: Qty Part Number Description Batch		<i>1/02404 08/02/12</i>
9.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 <i>(23) 08/02/12</i>
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per drawing		<i>08/02/12 (23)</i>
10.0	QC5 	INSPECT WORK TO CURRENT STEP <i>(counts) 08/02/12 X23</i>
Comment: INSPECT WORK TO CURRENT STEP		<i>08/02/12 X23</i>
11.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: 5741/37155		<i>AS 08/02/13 (23)</i>
12.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>(23) 08/02/14</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>min 2008/2/13 (23)</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

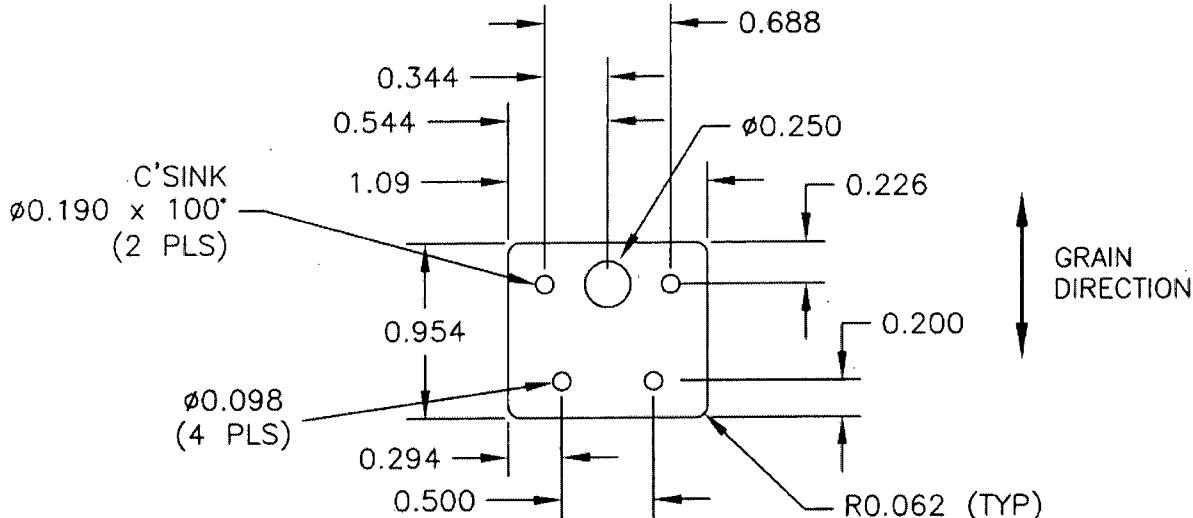
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

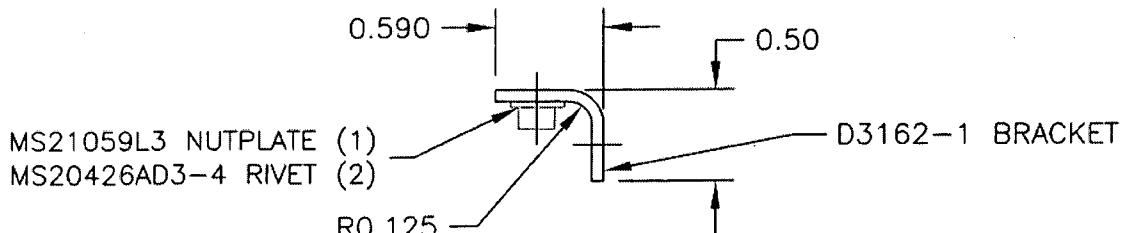
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	

RELEASED
05.12.01 *[Signature]*

D3162-1F FLAT PATTERN
(USED TO MAKE D3162-1 BRACKET)



D3162-041 BRACKET ASSEMBLY

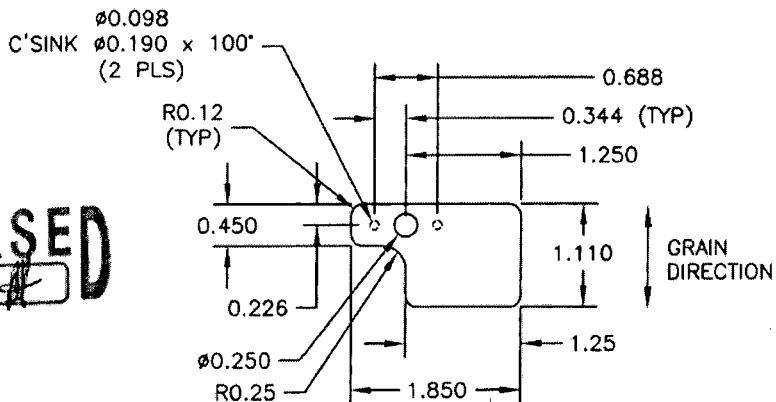
NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. UNCONTROLLED COPY SUBJECT TO S.063) NO. 37155
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

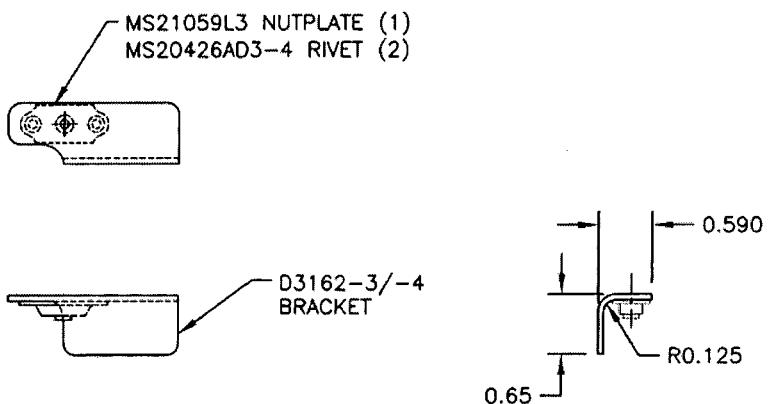
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO S.063
WITHOUT NOTICE
WORK ORDER
NO. 37155

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3162-3F FLAT PATTERN
(USED TO MAKE D3162-3/-4 BRACKETS)



D3162-043 BRACKET ASSEMBLY (SHOWN)
(D3162-044 BRACKET ASSEMBLY (OPPOSITE))

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37155*

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DART AEROSPACE LTD

Work Order: 37155

Description: BRACKET ASSEMBLY

Part Number: J0316A-1

Inspection Dwg: 13162-1 Rev: 6

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:

12

Audited by:

Prototype Approval:

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8-2-5

Date

Dotau

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	